

Stud Jan 27, 2017

Work Order ID 154728

154728

Page 1

Monday, December 19, 2016 5:09:41 PM

Item ID: D4635-142 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Replacement Panel Assembly, RH
 Start Date: 1/12/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/18/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: VS Date: 16/12/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4635	F

100

0.00

100

HandThermo

Memo

0.14

Hand Finishing Thermoforming

Pick Kit

JAN 12 2017 DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Small Fab

Small Fab

Memo

0.20

Assemble as per Dwg D4635-142
Bond foam core to inside of panel
3M Scotch Weld 1300 Batch: m13050

1- Scuff bonding surface to eliminate in-perfections and increase bonding and
clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads
using 3M Plastic welder II.(see note 8)

Batch # 135436Expiry Date Feb 2017

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9)

Batch: m135435

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

Smb
17/1/19

D 17-01-19

DAS
9
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

1 **SMB**
17/1/23

DAS
21
9-89 **JAN 24 2017**

DAS
21
9-89 **JAN 24 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator ☐	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing ☐	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐								
Misidentified ☐	☐	Past Due ☐								
			OTHER : ☐							

Picklist Print

Monday, December 19, 2016 5:09:46 PM

Page 1

Work Order ID: 154728

154728

Parent Item: D4635-142

D4635-142

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, RH

Start Date: 1/12/2017

Required Date: 1/18/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL
Update 13/07/09 DL verf:DD
13/12/09 DL
Ipp Rev. E Dwg Update 14/01/09 DL
Dwg. Update 15/01/27 DL

IPP Rev B
IPP Rev. C Dwg.
IPP Rev D Dwg Update
IPP Rev. F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-2		Manufactured	No			100	Each	0.0000	1	1			
D4635-2									**	B/SYTB1			Smb
Fwd Ceiling Panel, RH													
D4669-1		Manufactured	No			100	Each	20.0000	2	2			
D4669-1									**			JAN 12 2017	
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF004				20					
				125017				20					
D4695-042		Manufactured	No			100	Each	2.0000	1	1			
D4695-042									**			JAN 12 2017	
Channel Assembly, RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST446				2					
				129264				2					
D4732-3		Manufactured	No			100	Each	9.0000	1	1			
D4732-3									**			JAN 12 2017	
Label													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF005				9					
				120061				1					
				123201				8					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Picklist Print

Monday, December 19, 2016 5:09:46 PM

Work Order ID: 154728

154728

Parent Item: D4635-142

D4635-142

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, RH

Start Date: 1/12/2017

Required Date: 1/18/2017

Start Qty: 1.00

Required Qty: 1.00

D4732-31 Manufactured No

100 Each 10.0000 1 1

D4732-31

Label

**

JAN 12 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

MF005

10

123215

10

D4732-35 Manufactured No

100 Each 10.0000 1 1

D4732-35

Label

**

JAN 12 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

MF005

10

123217

10

D4732-7 Manufactured No

100 Each 9.0000 1 1

D4732-7

Label

**

JAN 12 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

MF005

9

123203

9

D5022-1 Manufactured No

100 Each 12.0000 1 1

D5022-1

Foam, Side Panel, Fwd

**

JAN 12 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

MF010

12

123925

2

126184

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

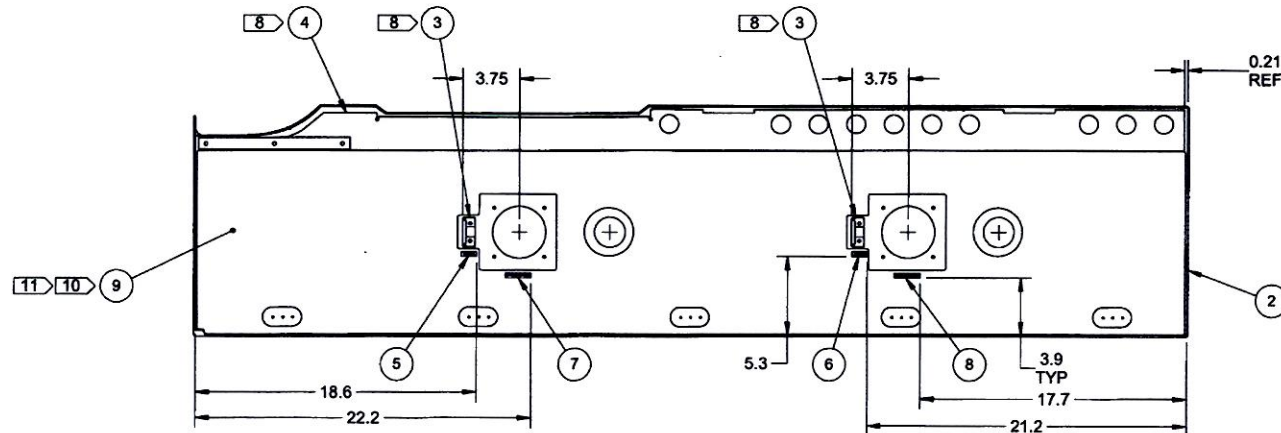
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OTHER : ☐					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154728

Vic
K2
16/12/20

ITEM	QTY	P/N	DESCRIPTION
1	X	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-2	RH, FWD CEILING PANEL
3	2	D4689-1	BRACKET
4	1	D4695-042	RH CHANNEL ASSEMBLY
5	1	D4732-3	LABEL
6	1	D4732-7	LABEL
7	1	D4732-31	LABEL
8	1	D4732-35	LABEL
9	1	D5022-1	FOAM, SIDE PANEL, FWD



D4635-142 RH, FWD CEILING REPLACEMENT PANEL ASSY

RELEASED
2015 JAN 26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4689-1 & D4695-042. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-2

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	DL	D4635	SHEET 10 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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